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12568

D2803-042

Job Sheet 189319



Part No: D2803-042

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/11/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV C IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP REV:G 16.06.23 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	2/11/19		0.00	0.17	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		DAS
							Small Fab - 4		36
							Small Fab - 5		9-89
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	2/11/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS
							QC 5 - 9		FEB 12 2019 68
							QC 5 - 50		9-89
							QC 5 - 30		
120	Powdercoat - 1 White GI(A)-B4B	2 pcs	2/11/19		0.00	0.16	Powdercoat - 1 - B4B		ML 19-2-13
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		

130 QC 3	2 pcs	2/11/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	DAS
				QC 3 - 36	36
				QC 3 - 38	9-89
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
150 Small Fab - 2 - B4B	2 pcs	2/11/19	0.00 0.17	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	DA'
				Small Fab - 4 - B4B	36
				Small Fab - 5 - B4B	9-8
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
160 QC 5	2 pcs	2/11/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Packaging 3-1 - Stock - B4B	2 pcs	2/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	ST-473 SA
				Packaging 3 - 10 - B4B	FEB 28 2019
180 QC 21 - SA	2 pcs	2/11/19	0.00 0.00	QC 21 - SA - 21	DAS 21 FEB 28 2019 9-89

Part Op 100 - (Small Fab) Press D2805-2 and D2809 into arm as per Dwg D2803

Descriptions: **110** - QC5- Inspect part completeness to step on W/O

120 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

130 - QC3- Inspect Part Finish

150 - (Small Fab) Assemble as per Dwg D2803.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

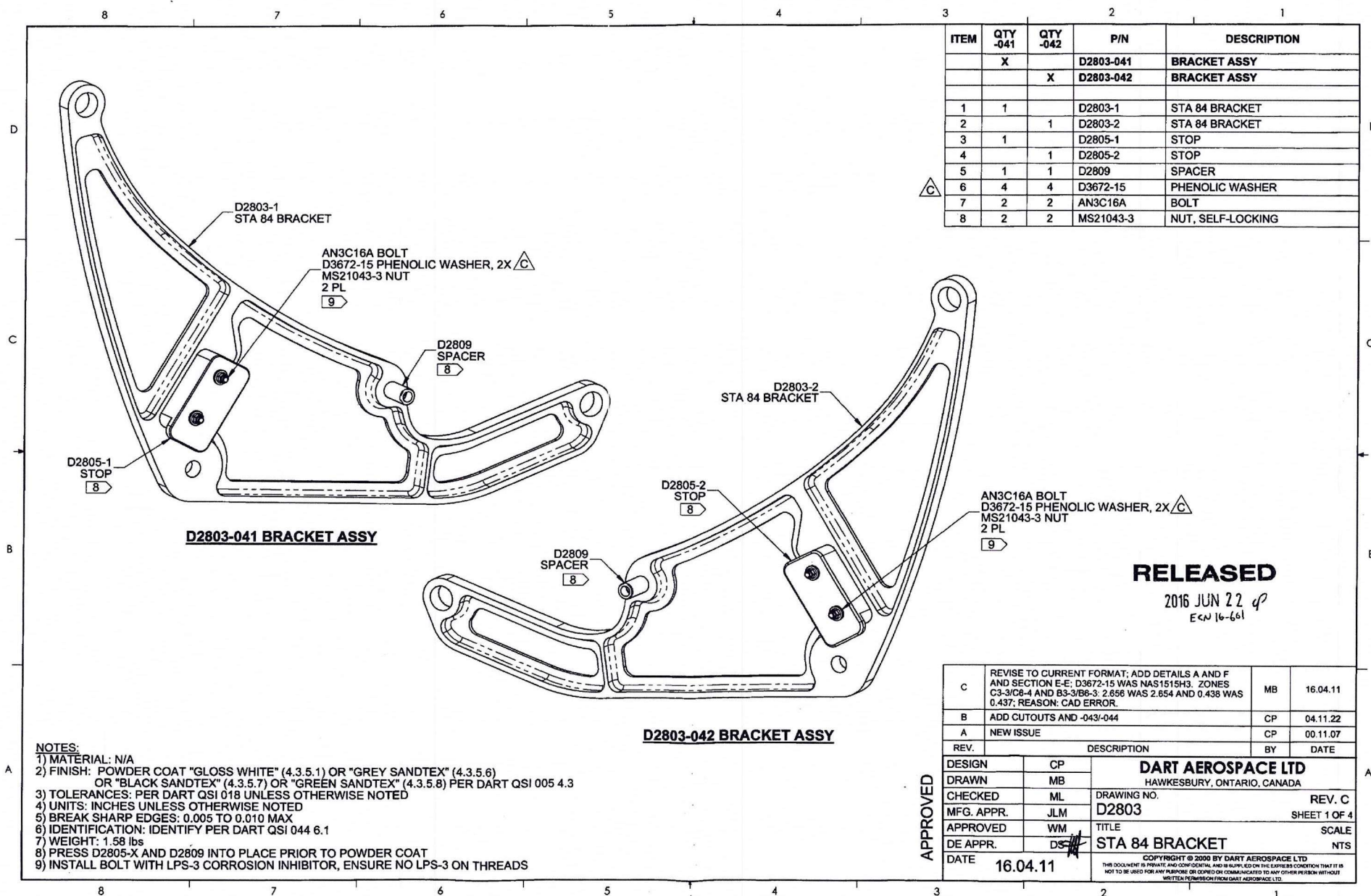
Part / Item	Component Name	Quantity	Operation	Container
D2803-2	Bracket	2 Ea (1 ea)	100-Small Fab - 1	F146565
D2805-2	Stop	2 pcs (1 ea)	100-Small Fab - 1	F1494761X
D2809	Washer	2 pcs (1 ea)	100-Small Fab - 1	50725.31
AN3C16A	Bolt	4 Ea (2 ea)	150-Small Fab - 2 - B4B	5057495
D3672-15	Phenolic Washer	8 pcs (4 ea)	150-Small Fab - 2 - B4B	5042874
MS21043-3	Nut	4 Ea (2 ea)	150-Small Fab - 2 - B4B	5149144

Job Allocations

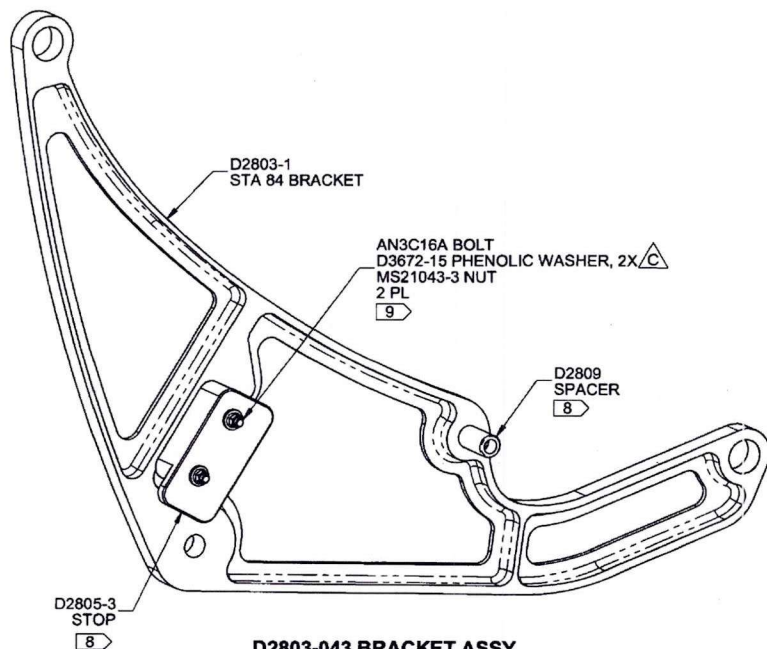
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	D2803-2	2	9	0
	D2805-2	2	1	0
	D2809	2	47	0
150-Small Fab - 2 - B4B	AN3C16A	4	54	0
	D3672-15	8	544	0
	MS21043-3	4	723	0

Part Specifications

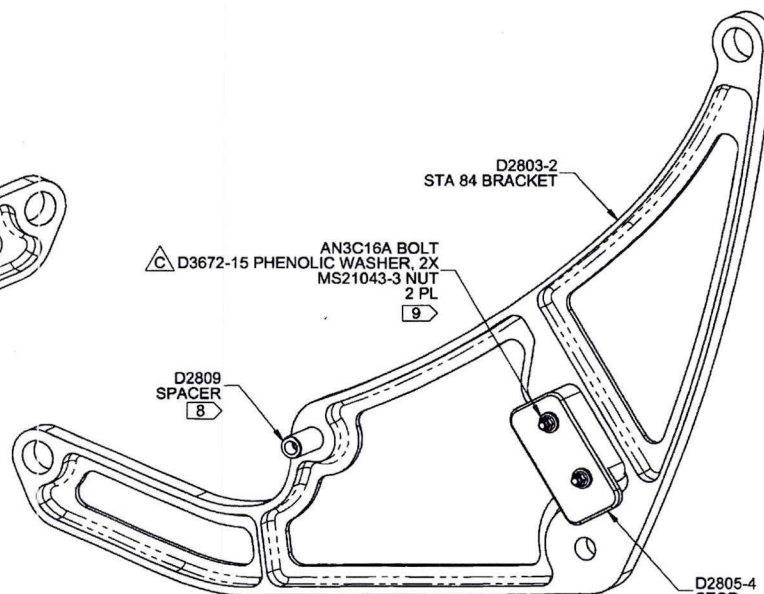
Specifications could not be found.



ITEM	QTY -043	QTY -044	P/N	DESCRIPTION
	X		D2803-043	BRACKET ASSY
		X	D2803-044	BRACKET ASSY
1	1		D2803-1	STA 84 BRACKET
2		1	D2803-2	STA 84 BRACKET
3	1		D2805-3	STOP
4		1	D2805-4	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2803-043 BRACKET ASSY



D2803-044 BRACKET ASSY

RELEASED

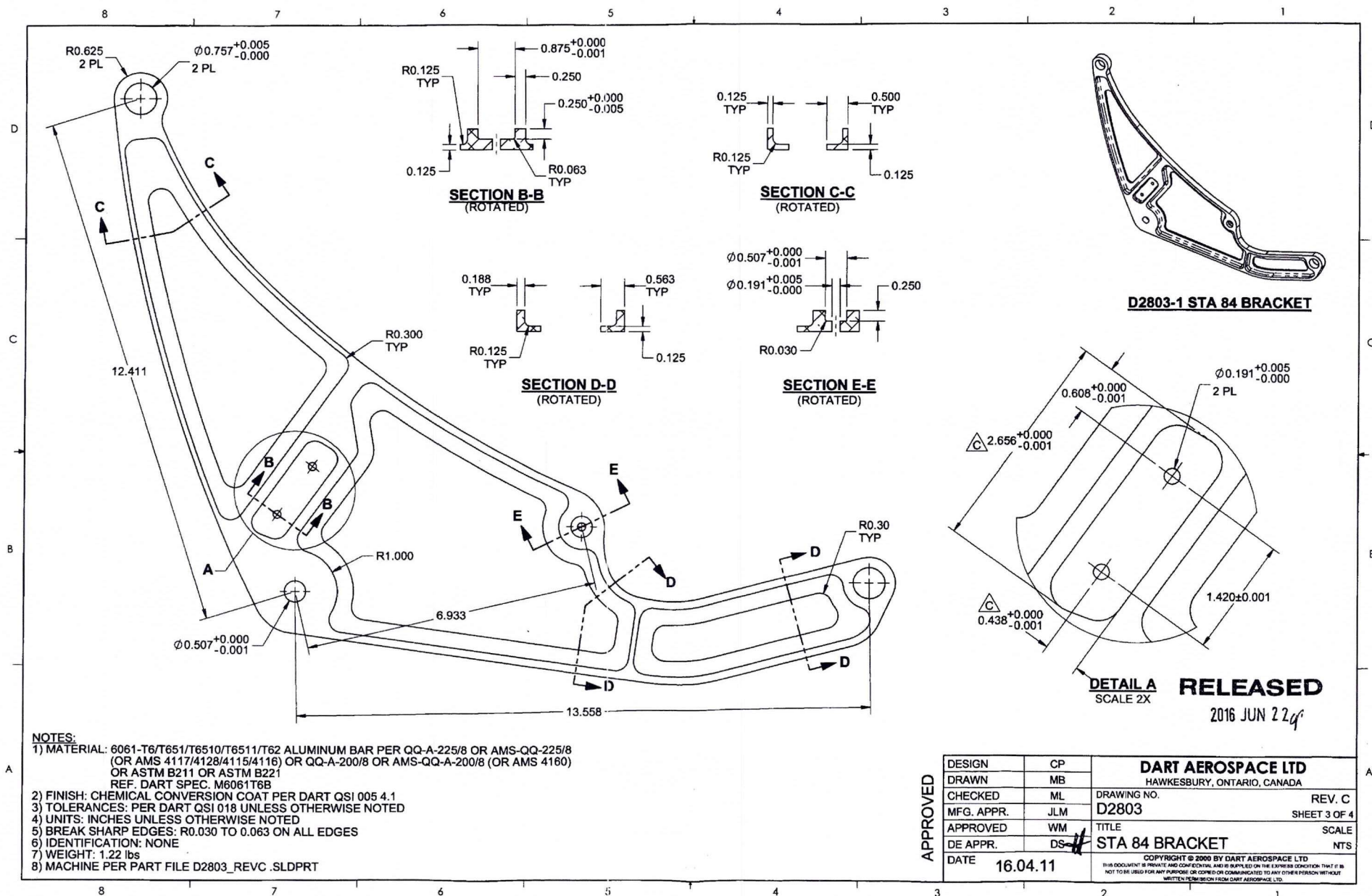
2016 JUN 22 *up*

NOTES:

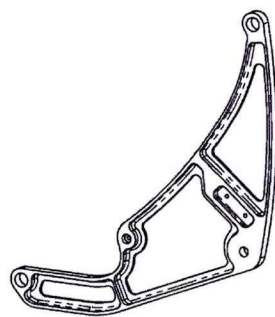
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.58 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

APPROVED	DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	DRAWN	MB	
	CHECKED	ML	
	MFG. APPR.	JLM	
	APPROVED	WM	
DE APPR.	D9		
DATE	16.04.11		

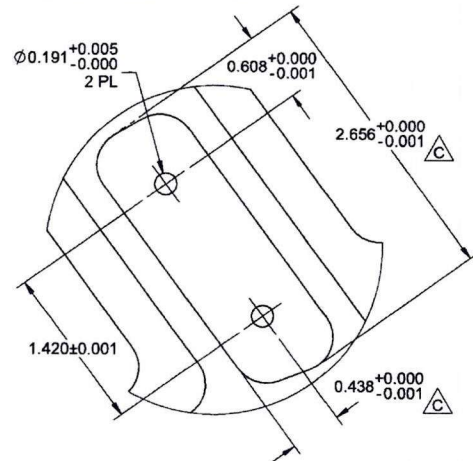
STA 84 BRACKET
SHEET 2 OF 4
SCALE
NTS
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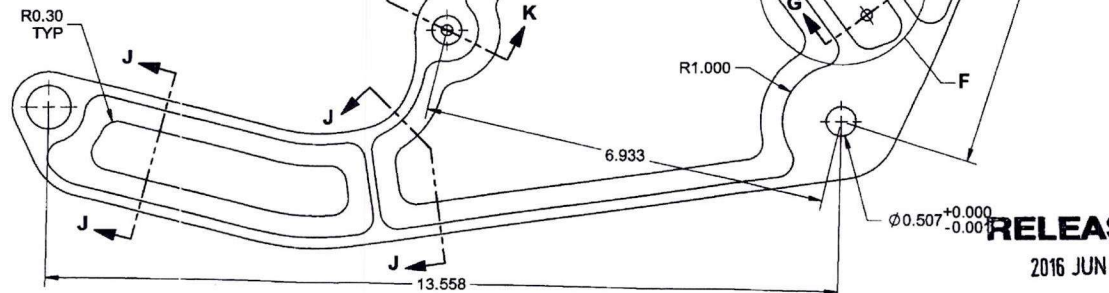
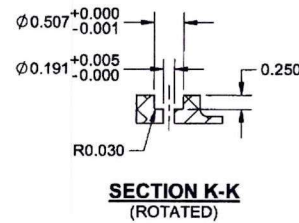
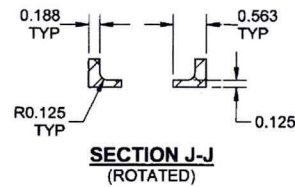
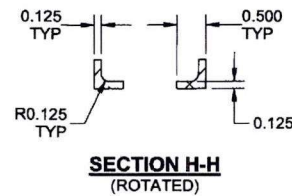
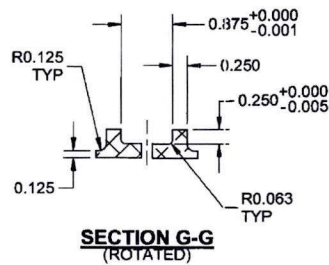
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D2803	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 84 BRACKET	NTS
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D2803-2 STA 84 BRACKET



DETAIL F
SCALE 2X



RELEASED
2016 JUN 22 *ep*

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.22 lbs
- 8) MACHINE PER PART FILE D2803_REV.C.SLDPR

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	JLM	D2803	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 84 BRACKET	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S150083

Part: D2803-042

Job No: 189319

Serial No/Batch: S150083

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/01/19